Wednesday, September 15, 2010 9:56:58 AM



Page 1

Item ID: D3910-1 Accept Setup Start **Revision ID:** Stop **Item Name:** Crosstube Lug **Start Date:** 9/14/2010 Start Qty: 6.00 **Cust Item ID:** Required Date: 9/21/2010 Reg'd Qty: 6.00 **Customer:** Reference: Run Start Date: 10-215 Tooling: **Process Plan:** Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Reject Tool ID Tool# Plan Accept Reject Insp. Work Center ID. Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** B D3910 100 0.00 A. A (10/09/27) Bandsaw Memo Jeaspa Bandsaw CUT BLANK 1.450" LONG 110 0.00 6 8 HAAS 1 0.00 SF ,0/09/24 Memo HAAS CNC vertical machine #1 , MACHINE AS PER FOLIO FA865 AND DWG FOLIO REV: 👭 DWG,REV: 13 **DEBURR**

W/O:			V	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CH	ANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	;	PAR #:	Fault Category: NC			NCR: Yes No DQA:			Date:	
	Re	esolution:	Disposit	ion:	QA: N/	C Clo	sed:		Date:	
NCR:			WORK OR	DER NON-CONFORM	IANCE (I	NCR)				
DATE	STEP	Description of NC	Corrective Action Section B			verificatio				Approval
	J	Section A	Initial Chief Eng	Action Description Chief Eng		Date	Section	C	Chief Eng	QC Inspector
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Work Order ID 62009

Page 2

Item ID:

Wednesday, September 15, 2010 9:56:58 AM D3910-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Crosstube Lug

Start Date:

9/14/2010

QC:

Start Qty: 6.00

Req'd Qty: 6.00 Required Date: 9/21/2010

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start



Stop

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/ **Run Hours**

2× 10/09/24

Tool ID

Tool # Plan Code

Accept Qty Qty

Run

Reject Reject Number

Insp. Stamp

0.00

130

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

10/09/29

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00 BR 15-9-30

Memo

0.00

Dart Aeı	rospace	e Ltd							•
W/O:			WC	RK ORDER CHANGE	ES			,	
DATE	STEP	PRO	PROCEDURE CHANGE						Approval QC Inspector
						-			
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Disposition	1:	QA: N/C C	losed:	,	Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	٦)		i.	
		Description of NC		Corrective Action Section	n B	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign o	& Sect	ion C	Chief Eng	QC Inspector

Chief Eng Chief Eng Date

Work Order ID 62009

Wednesday, September 15, 2010 9:56:58 AM



Page 3

Item ID:

D3910-1

Accept



Date:

Date:

Setup Start



Revision ID:

Item Name:

Required Date: 9/21/2010

Crosstube Lug

Start Date:

9/14/2010

Start Oty: 6.00

Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:

Process Plan:

Date: Date:_____ Tooling:

SPC (Y/N):

Start Stop

Stop

Sequence ID/

Work Center ID

150

Powdercoat

Powder Coating

Operation Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Identify as per dwg & Stock Location:

FinisH 16:55

Set Up/

Run Hours
0.00 DK 10-10-4.

0.00

Tool ID

Tool # Plan Code

Accept Qty Qty

Run

Reject Reject

Insp. Number Stamp

160

OC

Quality Control

QC3- Inspect Part Finish

Memo

1010101 M(=

0.00

170

Packaging Packaging

0.00

0.00

(6)

Memo

W/O:			W	ORK ORDER CHANGE	S					
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes No DQA: Date:					
	R	esolution:	Dispositi	on:	QA: N/C C	losed:		Date: _		
NCR:			WORK ORI	DER NON-CONFORMA	NCE (NC	R)				
DATE	STEP	Description of NC	Initial	n B Sign		cation	Approval	Approval		
		Section A	Chief Eng	Action Description Chief Eng	Date		ion C	Chief Eng	QC Inspector	
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Work Order ID 62009

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Wednesday, September 15, 2010 9:56:58 AM

Item ID:

D3910-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Crosstube Lug

Start Date: 9/14/2010 Required Date: 9/21/2010

Start Oty: 6.00

Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling: Date:_____

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/

Work Center ID

180

Operation

Description

OC21- Final Inspection - Work Order Release

Memo

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

10/10/05

Quality Control

0.00

U (0.10.65

W/O:			W	ORK ORDER CHANG	ES			
DATE	STEP	PRO	CEDURE CHA	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA:	Date: _	
	Re	solution:	Disposition	on:	_ QA: N/C Clo	sed:	Date: _	
NCR:		\	WORK ORD	ER NON-CONFORMA	ANCE (NCR)		
DATE	OTED	TED Description of NC	Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

Picklist Print

Wednesday, September 15, 2010 9:57:02 AM

Work Order ID: 62009

D3910-1 Parent Item:

Parent Item Name: Crosstube Lug



Start Date: 9/14/2010

Required Date: 9/21/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD

REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			100	f	364.5171	0.13	0.821053			

Lug Extrusion

Location	Loc Qty	Loc Code
MAT06	364.5170795	
43722	180	
45800	184.517079	

0.8210 ft B.A 10/09/27

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH	ANGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:			_ NCR:	Yes N	lo DQ	A :	Date: _	
	Re	esolution:	Disposition	on:	_ QA: N	C Clo	sed:		Date: _	
NCR:	NCR:		WORK ORE	DER NON-CONFORMA	NCE (I	NCR)				
DATE	STEP	Description of NC		ion B Sign &		Verific	ation	Approval	Approval	
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti	on C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	42699
Description: Crosstube Lug	Part Number:	D3910-1
Inspection Dwg: D3910 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerande	Dimension	лосорс	110,001	Inspection	
4.45	+/-0.030	4454			V- 18-12	1
1.38	+/-0.030	1.377			**	
0.27 Ref	+/-0.030	.275			High gar	ge
0.31	+/-0.030	. 305	1		V SE-12	<u> </u>
0.735 Ref	+/-0.010	.725	/		11	
2.20	+/-0.030	2.203	/		High nava	
0.375	+/-0.010	.375	/		V-55-12	
Ø0.191	+0.005/-0.001	.193	/		ti.	
R0.38	+/-0.030	.38			lad garage	
0.38	+/-0.030	. 38	_		V-57-12	
0.625	+/-0.010	.623	_		11	
0.375	+/-0.010	.375	٠ ·			
3.700	+/-0.010	3,702	. 7		11.1	
0.625	+/-0.010	625	/			
0.375	+/-0.010	.375	<i></i>		11	
R0.34	+/-0.030	1,34	·/		Rody	
	-					
·			,			
			18.41			
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			X			
easured by:	8.	Audited by:	过わ)	Preliminary A	Approval:

Measured by:

Date: 10/09/18

Audited by: Date: 10/09/29

Preliminary Approval:

Date: 10/09/29

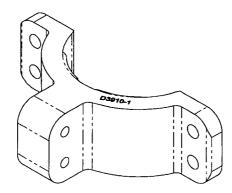
Revised by Approved

A 10.06.07 New Issue

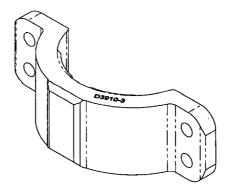
	rospace	Ltd							
W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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				QA: N/C Closed: Dat					
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NC	₹)			
		Description of NC		Corrective Action Section	on B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector

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D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

RELEASED

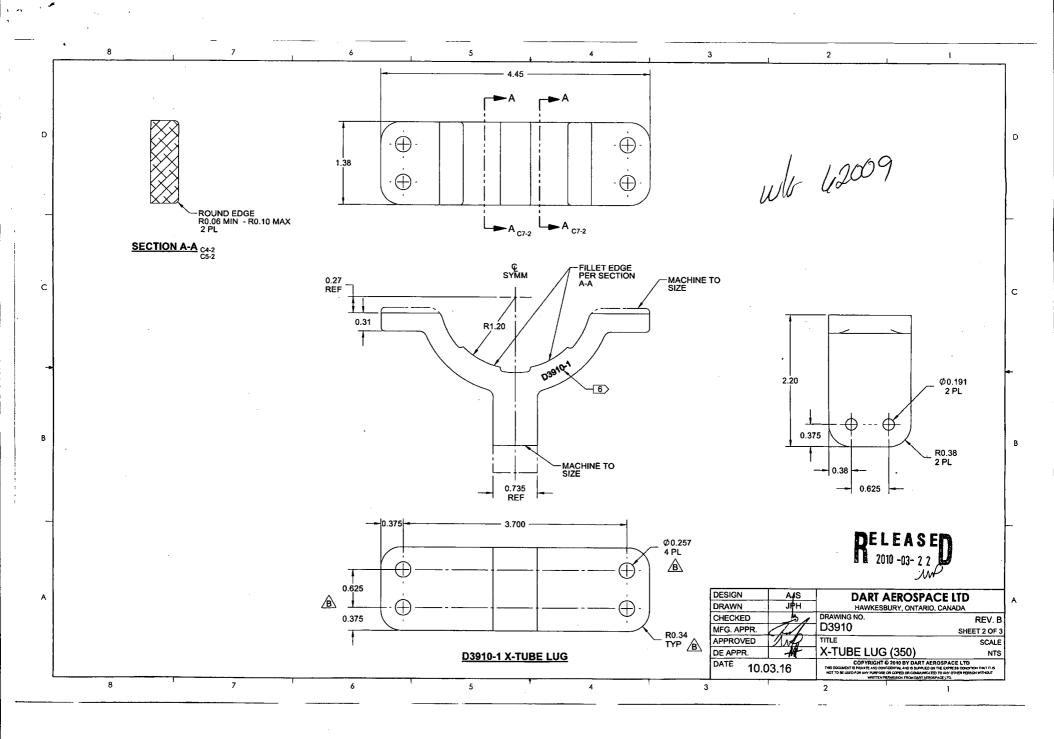
NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005
7) WEIGHT -1: 0.32 lbs

D

C

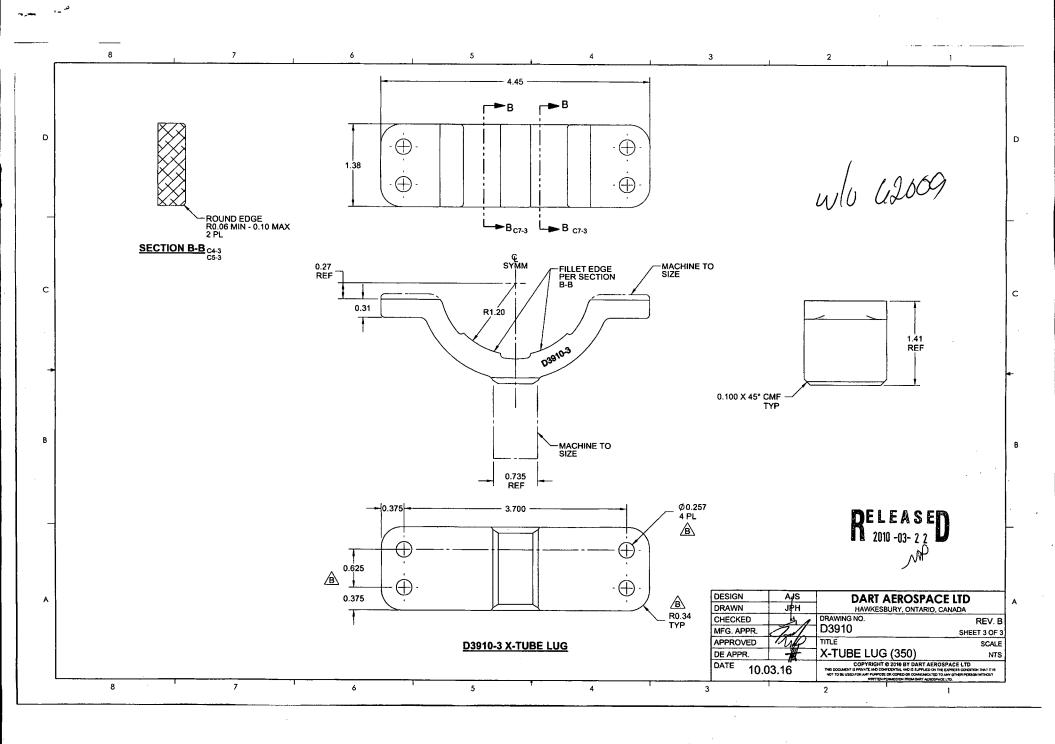
В	Ø0.257 FILLET REASO	HOLES WAS RO N: SEE	: 4 PL W 0.50 (A3-2 TR-D350	AS 2 PL (A3-2) & (A3-3); R0.34 2) & (A3-3). -607-2	ЈРН	10.03.16				
Α	NEW IS				JPH	10.03.04				
REV.			C	DESCRIPTION	RIPTION BY DAT					
DESIGN	1	Α	JS	DART AEROSPACE LTD						
DRAWN	1	J	РН	HAWKESBURY, ONTARIO, CANADA						
CHECK	ED		3/	DRAWING NO.						
MFG. A	PPR.		//	D3910		SHEET 1 OF 3				
APPRO	VED	M	7. –	TITLE		SCALE				
DE APPR.				X-TUBE LUG (350)						
DATE	10.0	3.16	}	COPYRIGHT © 2010 BY DART / THIS DOCUMENT IS PRIVATE AND CONFIDENTIA, AND IS SUPPLIE NOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMENT WINTERS PERSONS FROM DUST A	DON'THE EXPRES	SS CONDITION THAT IT IS				

W/O:			W	ORK ORDER CHANG	ES			
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DATE	STEP	Description of NC	Corrective Action Section			Verification	Approval	Approval
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